

Work Order ID 128916

128916

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Tuesday, January 27, 2015 7:54:10 AM

Item ID: D3136-045 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Window Assembly
Start Date: 1/26/15 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 1/26/15 Req'd Qty: 6.00 *6* Customer:
Reference:

Approvals: Process Plan: MLS Date: 1501-29 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3136	F								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
Plexiglas G. 125	Dwg Rev: <u>F</u>								
	Prog Rev: <u>F</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89
FEB 24 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	THERMOFORMING MACHINE	0.00				✓6			DAS 07 9-89
130	Thermoform	0.00							15/03/03
Thermoforming Machine	Memo								
	1-Thermoform as per Dwg D3136 and Work Instruction WI006								
	Dwg Rev. <u>F</u>								
	WI Rev. <u>D</u>								
	2- Engrave Part # and Batch # , and affix labels (D3108-9)								
150	HAND FINISHING THERMOFORMING	0.00				x6			DAS 07 9-89
150	HandThermo	0.00							15/03/03
Hand Finishing Thermoforming	Memo								
	Water sand and buff to remove scratches as required								

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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect edge and window deformation, wrap in plastic	0.00 0.00				<u>(6)</u>			DAS 38 9-89 MAR 10 2015
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>S-425</u> Memo	0.00 0.00				<u>6</u>			DAS 6 9-89 MAR 05 2015
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				<u>MLJ</u>			15-03-11 ME 15-3-10

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Picklist Print

Tuesday, January 27, 2015 7:54:09 AM

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Work Order ID: 128916

128916

Parent Item: D3136-045

D3136-045

Parent Item Name: Window Assembly

Start Date: 1/26/15

Required Date: 1/26/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:C 15.02.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3108-9		Manufactured	No				Each	351.0000		12			DAS 07 9-89
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D3108-9

Decal

Location	Loc Qty	Loc Code
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ST017	351	
46546	351	

MACRLICS.125

Purchased

No

sf

34.0000

26.84211

MACRLICS 125

1/8" Polycast II Sheet

Location	Loc Qty	Loc Code
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MAT019	34	
m130047	34	

131524

32

15/03/03

015/02/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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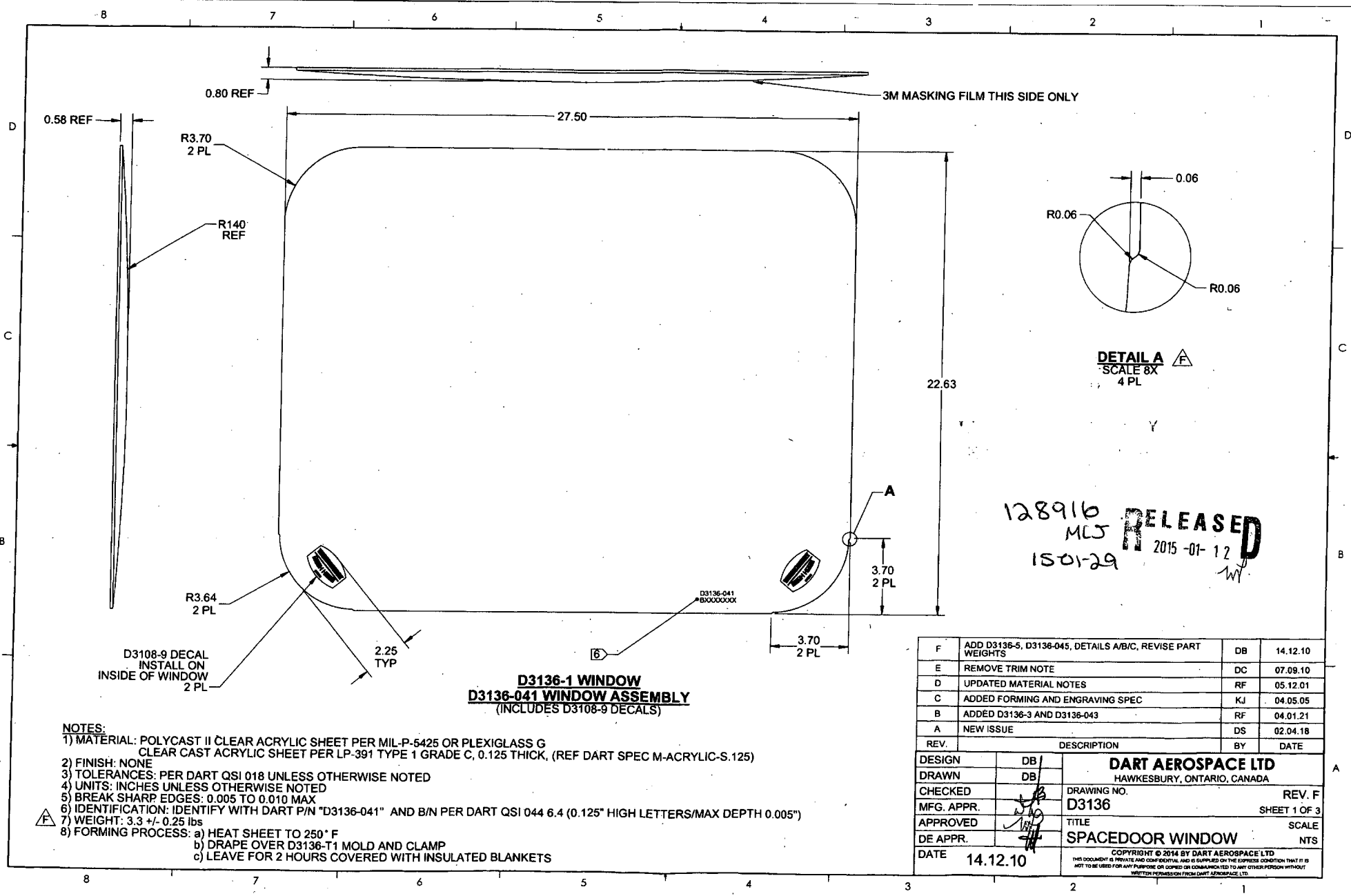
Work Order update only ☐

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128916
MLJ
1501-29
RELEASED
2015-01-12
WJ

**D3136-1 WINDOW
D3136-041 WINDOW ASSEMBLY**
(INCLUDES D3108-9 DECALS)

- NOTES:**
- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLASS G
CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK, (REF DART SPEC M-ACRYLIC-S.125)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3136-041" AND B/N PER DART QSI 044 6.4 (0.125" HIGH LETTERS/MAX DEPTH 0.005")
 - 7) WEIGHT: 3.3 +/- 0.25 lbs
 - 8) FORMING PROCESS: a) HEAT SHEET TO 250°F
b) DRAPE OVER D3136-T1 MOLD AND CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

F	ADD D3136-5, D3136-045, DETAILS A/B/C, REVISE PART WEIGHTS	DB	14.12.10
E	REMOVE TRIM NOTE	DC	07.09.10
D	UPDATED MATERIAL NOTES	RF	05.12.01
C	ADDED FORMING AND ENGRAVING SPEC	KJ	04.05.05
B	ADDED D3136-3 AND D3136-043	RF	04.01.21
A	NEW ISSUE	DS	02.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3136	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SPACEDOOR WINDOW	NTS
DATE	14.12.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

